



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7810
Job Sheet 181394



Part No: 647.7810

Job Qty: 40 ea

Part Name: Bracket A



Part Weight: 0 lbs

Status: Scheduled

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev: A RQ 15.08.06 Verified by DD

Ship Via:



Container No: S115101



Part: 647.7810

Job No: 181394

Serial No/Batch: S115101

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/02/18

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		9/10/18	0.00	0.00	Start Up Machining-1		JIP 18-10-02
100	Bandsaw	40 pcs		9/10/18	0.00	1.26	Bandsaw1		JIP 18-10-02
110	CNC Vertical Machining	40 pcs		9/10/18	0.30	34.19	HAAS1-1		JIP 18-10-02
120	QC	40 pcs		9/10/18	0.00	0.00	QC2 Machining-1		JIP 18-10-02
130	QC	40 pcs		9/10/18	0.00	0.00	QC8 Machining-1		KT 2018-10-07
131	HandFinish	40 pcs		9/10/18	0.00	0.00	HandFinish2 - not required		
140	Outsource	40 pcs		9/10/18			ATG001-VC	PO: 041374	OCT 09 2018
150	Packaging	40 pcs		9/10/18	0.00	0.00	Packaging2		NOV 17 2018
155	QC	40 pcs		9/10/18	0.00	0.00	QC5		NOV 28 2018
180	Packaging	40 pcs		9/10/18	0.00	0.00	Packaging3-1	CCK 076	NOV 29 2018
190	QC21-SA	40 Ea		9/10/18	0.00	0.00	QC21		NOV 29 2018

Part Op 100 - Cut Blank at 10.313"

Descriptions: 110 - 1-Machine per folio FB408

140 - Issue P/O to ATG : _____ Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S6.000X0.250	7075-T6S Sheet 6" Thick Plate X 0.25" Wide	34.3600 ft (.859 ea)	90-Start up Operation	

(.8647ea)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S6.000X0.250	34	48	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket A	0.090inches $\pm$ 0.005	0.095 0.085	0.09	
2	Bracket A	45.000inches $\pm$ 0.500	45.500 44.500	45°	
3	Bracket A	0.255inches $\pm$ 0.005	0.260 0.250	0.252	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

4	Bracket A	9.810inches $\pm$ 0.010	9.820 9.800	
5	Bracket A	0.260inches $\pm$ 0.010	0.270 0.250	Radius 0.26
6	Bracket A	29.900Degrees $\pm$ 0.500	30.400 29.400	Angle 29.9
7	Bracket A	3.671inches $\pm$ 0.005	3.676 3.666	3.673
8	Bracket A	16.900Degrees $\pm$ 0.500	17.400 16.400	Angle 16.9
9	Bracket A	9.463inches $\pm$ 0.005	9.468 9.458	9.463
10	Bracket A	100.000Degrees $\pm$ 0.500	100.500 99.500	Angle 100°
11	Bracket A	18.700Degrees $\pm$ 0.500	19.200 18.200	Angle 18.7°
12	Bracket A	9.092inches $\pm$ 0.002	9.094 9.090	9.092
13	Bracket A	3.332inches $\pm$ 0.002	3.334 3.330	3.332
14	Bracket A	7.300inches $\pm$ 0.002	7.302 7.298	7.300
15	Bracket A	0.397inches $\pm$ 0.002	0.399 0.395	0.397
16	Bracket A	2.575inches $\pm$ 0.002	2.577 2.573	2.577
17	Bracket A	2.475inches $\pm$ 0.002	2.477 2.473	2.475
18	Bracket A	0.500inches $\pm$ 0.002	0.502 0.498	0.5
19	Bracket A	0.400inches $\pm$ 0.002	0.402 0.398	0.4

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DAS
52 18/09/30
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041274**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041274
PO Date: 10/9/18
Due Date: 11/30/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:
Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183919	647.7611	Lower Deflector Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7600	Firmed	-	11/25/18	4 pcs	0 pcs	4 pcs	\$14.59/pcs	\$58.36
	181390			Firmed	-	11/25/18	46 pcs	0 pcs	46 pcs	\$14.59/pcs	\$671.14
Sub Total:							50	0	50		\$729.50
2	181394	647.7810	Bracket A Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	-	11/25/18	40 pcs	0 pcs	40 pcs	\$17.04/pcs	\$681.60
3	175868	RBW6205G09132-3G-1	Base -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	11/25/18	6 pcs	0 pcs	6 pcs	\$42.54/pcs	\$255.24



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER
PO041274

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	178661	RBW6205G09132-3G-3	Block -Issue P/O to ATG: - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	-	11/25/18	9 pcs	0 pcs	9 pcs	\$14.54/pcs	\$130.86
Grand Total:											\$1,797.20

Order Notes

Procurement Quality Clauses

A005 right of entry

A012 chemical and physical test report

A016 personnel qualification

A017 raw material identification (as applicable)

A022 Apical Processing

A024 process certifications

A026 certification of material conformance

A041 quality management system

A042 dart notification by supplier

A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/14/18 8:07 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916519

Date: 16-Nov-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 40 ea	Part: 647.7810 ✓ Bracket A Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23949	Rev: A	PO: PO041274 ✓ Line: 2
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>16/11/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

